

Date:  
User:Wednesday, 06/05/2009 8:45:54 AM  
Melanie Fauteux

## Process Sheet

AOG

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: FRAME
<b>Job Number</b>	: 47759		
<b>Estimate Number</b>	: 10300		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D32241
<b>This Issue</b>	: 06/05/2009	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D3224 REV A
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 44164	<b>Drawing Revision</b>	: A
	<b>Type</b> : SMALL /MED FAB	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 06/05/2009
<b>Checked &amp; Approved By</b>	: <u>YMF 09-05-06</u>	<b>Qty:</b>	6
<b>Comment</b>	: Est Rev:A New Issue 05-11-06 JLM	<b>Um:</b>	Each
	Est: B 06.11.15 waterjet EC		

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S063 2024-T3 .063 sheet



Comment: Qty.: 5.4600 sf(s)/Unit Total: 32.7600 sf(s)

2024-T3 .063 thick aluminum sheet

Batch: 110980 1B 9-5-6

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3224

Dwg Rev: A 1B 9-5-6Prog Rev: A2-Deburr if necessary 1B 9-5-6

6

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

1B 09-05-05

5.0 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Deburr

1B 090505

1

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Drawing Name: FRAME

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Part Number: D32241

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3224

N/AB

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-05-05

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 00541

MZA 09-05-06

Continue here Dacos

DTD

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPD 47766.

8/09/05/06 (K4)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/06

Job Completion



MFA 09-05-06

Start time: 2:00  
 Temp: 32.0°  
 Finish time: 2:30

8b Powder Coat Black Saddle  
 Qty 126 By

4 09/05/06  
 FZ.

Process

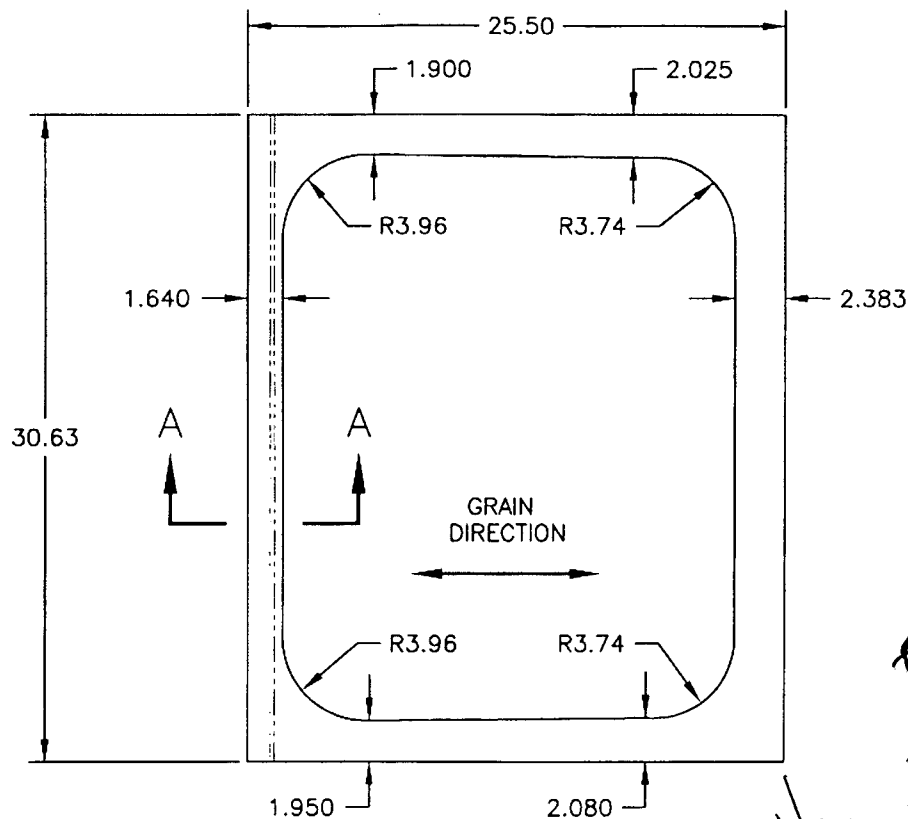
8c 23 inspect Powder Coat  
 Qty 126 By  
 4 09/05/06  
 S 02/05/06



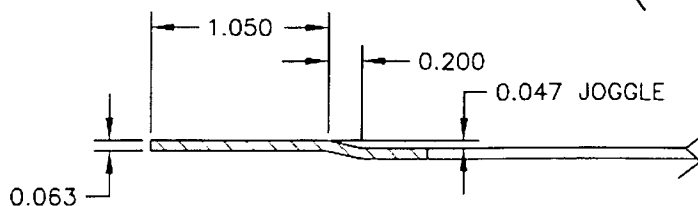


DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3224	REV. A SHEET 1 OF 1
DATE 03.10.21		TITLE FRAME	SCALE NTS
A	03.10.21	NEW ISSUE	

RELEASED  
040203



D3224-1



SECTION A-A  
SCALE 8:1

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 2) MATERIAL: 2024-T3 (QQ-A-250/4), 0.063 THICK (REF. M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

1054h  
23 1/2  
DAVID IS WILLING TO APPROVE THIS MOD FOR SPACE DODD

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